Work Orde		3495		Pa	Page 1								
Item ID: Revision ID: Item Name:	D2199-23 Strut	0270			Accept	*	1 900	040	100)* s	etup Star Stop	IVOSI	
Start Date: Required Date: Reference:	6/24/13 7/06/13	Start Qty: 4.00 Req'd Qty: 4.00		*4* *4*			Cust Item I Customer:	D:					
Approvals:	Process Pla	an: MCJ		s-06-21	✓ Tooling: SPC (Y/N):			ite:	- ·	R	un Star Stop	"NR I	
Sequence ID/ Work Center II		Operation Description		y gang	Set Up/ Run Hours	•	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stam	
Draw Nbr D2199	-\	vision Nbr				· ·				_		A . (107/03
100 *100* Brake NC		NC BRAKE			0.00	<u> </u>				4			
Brake NC			Dwg D2199 an	nd Spec Con	trol Dwg D2638				d.	:	· · · · ·		
110.		Small Fab			0.00	e e				4	- 1 - 1 - 1		1/
Small Fab		Memo Deburr	Appropriate Control of the Control o		0.00	;							1-3/07/
120		QC5- Inspect part com	pleteness to ste	p on W/O	0.00	A				· u :		Pro Sales and a second	
120 QC Quality Control	The state of the s	Мето			0.00	7,0				- j	·	**************************************	· · · · · · · · · · · · · · · · · · ·

DQA:			Date:												
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE		ork Order up	odate only		AEROSPACE	
M/auli Oud						DISPOSITION			AGA		PARTMENT				
Work Ord	er: -					Dania di	,				¬			<u>.</u>	
Part No.						Rework Scrap		Skid-tube Crosstube Machining Small Fab			Water Jet Prod. Eng. Coor.			Engineering Quality	
NCR No.					Use-as-is Suspected Unapproved		Thermoforming Finite Comp						Other		
Root	T			,	Desci	ription of work order update	ı	Initial	Action		Sign &		T		
Cause		Date	Step	Qty		or non-conformance	l	ief Eng	Description		Date	Verification	n	QC Inspector	
Design	П		<u> </u>						<u> </u>						
Doc/Data	П														
Equip/Tooling	Н												l	F	
Handling/Pre														<i>f</i>	
Material														<i>†</i>	
Operator													ľ	·	
Offset/Setup															
Process	П												1		
Supplier	П													İ	
Training													0		
Transport													.		
Unapproved													-		
:. <u></u>				<u> </u>			FAI	ULT CAT	EGORY		<u></u>	<u> </u>			
Landi	ng G	iear	i			General									
	П	Bending				Bend		Folio/P	rogram	Г	Outside Dime	ensions		Pressure/Forced	
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under			Set-up	
	Cracks					Broken/Damage/Defect		Hardwa	re		Part Incorrec		-	Temperature/Cure	
	Crimp/Kink/Ripple/Wave				 -	Burrs		ł	on Incomplete/Unqualified	,	Part Lost/Mis		-	Weld	
	Cuffs					Contamination		1	ions Incomplete/Unclear		Part Moved	-	-	Wrong Stock Pulled	
	Crushing				-	Countersink		1	ned/off center		Positioned W		لـــا	T. Sing Stook I dired	
	Heat Treat					Cut Too Short		Mislabe		<u> </u>	Power Loss/S			Other	
	├ ─┤			Drawing	-	Misread		Ц	1. 55. 2000/5			,			
	-	Marks/Ch				Drill Holes	Off-set							·	
	-	Turning S				Finish		1	Calibration						
	Wave/Twist in Tube					Fit/Function	\vdash	1	Sequence						

Work Orde		3495		Page 2					
Item ID: Revision ID: Item Name:	D2199-23 Strut			Accept	*N900040	100*	c Setup	Start Stop	*NS1* *NS2*
	6/24/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:				1 W L 17
Approvals:	Process Pl	an:	Date:	Tooling:	Date:		Run	Start	*NR1*
	QC:		Date:	SPC (Y/N):	Date:			Stop	*NR2*
Sequence ID/ Work Center II 130 *130* Powdercoat Powder Coating	N.	Operation Description White Gloss(Ref: 4.3.5.2 Memo START TIM	97	Set Up/ Run Hours 0.00 0.00 OVEN TEMPERATURE			Accept Re Qty Qt		Reject Insp. Number Stamp
*140 *140* QC Quality Control		QC3- Inspect Part Finisl Memo		0.00		4	4 b_	H	13712
150 *150* Packaging		Identify as per dwg & Si	lock Location: 572	0.00			4x		M.W. 13-C

Packaging

DQA:			Date:												
OA Classed			Data			WORK ORDER NON-	·CC	ONFO	RMANCE / U		W- 1 O 1		AEROSPACE		
QA Closed:			Date:							V	Vork Order uj	odate only			
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS			
	-					Rework			Skid-tube	Crosstube		Water Jet	Engineering		
Part N	10			•		Scrap		i	Machining	Small Fab		d. Eng. Coor.	Quality		
NCR No.				Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other				
										` _					
Root		Descriptio				ription of work order update	ı	nitial	Act	ion	Sign &		1		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector		
Design															
Doc/Data															
Equip/Tooling	\Box														
Handling/Pre	\Box					-									
Material															
Operator													1		
Offset/Setup	╝														
Process						-									
Supplier						1					1				
Training						·			1		[
Transport															
Unapproved															
							FAI	ULT CA	TEGORY.			******			
Landir	ng G	ear				General									
		Bending				Bend		Folio/F	rogram	Γ	Outside Dim	ensions	Pressure/Forced		
		Centre No	t Concer	ntric		BOM/Route		Grain		Γ	Over/Under	tolerance	Set-up		
		Cracks				Broken/Damage/Defect		Hardwa	ire	. [Part Incorre	ct	Temperature/Cure		
		Crimp/Kink/Ripple/Wave				Burrs		Inspect	ion Incomplete/Ur	nqualified '	Part Lost/M	issing	Weld		
	Cuffs					Contamination		Instruct	ions Incomplete/U	Jnclear	Part Moved	· · · · · · · · · · · · · · · · · · ·	Wrong Stock Pulled		
	Crushing					Countersink		ł	ned/off center	<u> </u>	Positioned \	<u></u>	⊸		
	Heat Treat					Cut Too Short		Mislabe		<u> </u>	Power Loss/		Other		
	Inspection Strip in Tube					Drawing		Misread			- - ·	~ <u>L</u>			
	$\overline{}$	Marks/Ch	· .			Drill Holes		Off-set							
		Turning So	equence			Finish		Out of							
	Wave/Twist in Tube					Fit/Function		ł	Sequence		<u></u>		· · · · · · · · · · · · · · · · · · ·		

Work Orde		3495		*10.3	495*		***			Page 3
Item ID: Revision ID: Item Name:	D2199-23 Strut			Accept	*N90004010			* Setu	ıp Start Stop	11/2
Start Date: Required Date: Reference:	6/24/13 7/06/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:				
Approvals:	Process Pl		Date:	Tooling: SPC (Y/N):		nte:		Run	Start Stop	"NR1"
Sequence ID/ Work Center II 160 *160* QC Quality Control	D	Operation Description QC21- Final Inspection - Wo	ork Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	_	•	Reject Insp. Number Stamp

DQA:	-	Date:			WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:		Date:			WORK ORDER NON-	-C(JNFUI	RIVIANCE / UPDATE	W	ork Order up	odate only	AEROSPACE			
14/ a.ul. O.u.d.a.					DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS				
Work Order	G			_	Rework	ı		Skid-tube Crosstube	T Engineering						
Part No	Ω				Scrap			Machining Small Fat	-	Pro	Water Jet d. Eng. Coor.	Engineering Quality			
					Use-as-is		B .	noforming Finishing	—	₹	re/Packaging	Other			
NCR No.					Suspected Unapproved			Large Fab Composite	_]	Supplier				
Root	oot Des				ription of work order update	1	Initial	Action		Sign &					
Cause	Date	Step	Qty		or non-conformance	ı	nief Eng			Date	Verification	QC Inspector			
Design		· ·													
Doc/Data															
Equip/Tooling		1													
Handling/Pre															
Material															
Operator															
Offset/Setup															
Process		ļ						·							
Supplier															
Training															
Transport															
Unapproved															
<u> </u>						FA	ULT CA	TEGORY			-				
Landin	g Gear				General		_			_	_				
	Bending				Bend	L	Folio/F	Program		Outside Dim	ensions	Pressure/Forced			
	Centre No	ot Conce	ntric	· .	BOM/Route		Grain			Over/Under	tolerance	Set-up			
L	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorred	ct	Temperature/Cure			
	Crimp/Kir	nk/Ripple	/Wave		Burrs	L	Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld			
	Cuffs Contamination				Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled			
	Crushing Countersink					Misalig	gned/off center		Positioned V	Vrong	<u></u>				
	Heat Treat Cut Too Short				Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other			
	Inspection Strip in Tube Drawing					Misread	d								
	Marks/Ch	natter			Drill Holes	Off-set									
	Turning S	equence			Finish	Out of Calibration									
	Wave/Twist in Tube Fit/Function						Out of	Sequence							

Page 1

Work Order ID:

103495

Parent Item:

D2199-23

Parent Item Name:

Strut

Start Date: 6/24/13

Required Date: 7/06/13

Start Qty: 4.00

Required Qty: 4.00

Comments:	IPP: D02.06.10F	Rem polish & add fi	inishNG/	CC								•	•
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049 304 RD Tube .750 x .049W	<i>y</i>	Purchased	No			100	f	438,2989	2.2	9.263158		Sp. 1	1362/07

Loc Code Location Loc Oty MAT017 438.2988825 122312 13.3 122468 0.0000325 124768 83.93245 125068 52.0664 125513 289

DQA:			Date:												
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			_		AEROSPACE	
QA Closed:	_		Date:				_		<u> </u>	W	ork Order up	odate only	<u></u>	·	
Work Orde	er:					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS		;	
	_	 _				Rework			Skid-tube Crosstube	٦]	Water Jet	\neg	Engineering	
Part No.					Scrap	Machining Small Fab			Prod. Eng. Coor.			Quality			
						Use-as-is			noforming Finishin	-	Rec/Store/Packaging			Other	
NCR No.				Suspected Unapproved			Large Fab Composite			Supplier	ヿ				
											_	_			
Root	T	Desc			Desci	ription of work order update	1	Initial	Action		Sign &		T		
Cause	\dashv	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	1	QC Inspector	
Design															
Doc/Data	Ш										:			!	
Equip/Tooling	Ц		i '												
Handling/Pre	Ц														
Material	Н														
Operator	Н														
Offset/Setup	Н			*						:					
Process	Н														
Supplier	Н										,				
Training	Н												İ		
Transport	\dashv														
Unapproved							FAI	III T CAT	<u> </u> regory		<u></u>				
Landi	ng G					General	FAI	ULT CA	IEGURY				—		
2011011		Bending				Bend		leolio/E	Program	Г	Outside Dim	onsions [٦,	Pressure/Forced	
	\vdash	Centre No	nt Concer	ntric		BOM/Route		Grain	TOBIATI	-	Over/Under	<u> </u>	_	Set-up	
	\vdash	Cracks	0011001	1010	-	Broken/Damage/Defect	\vdash	Hardwa	ırα	\vdash	Part Incorred	+		Temperature/Cure	
•	\vdash		nk/Ripple	/Wave		Burrs	 	ł	ion Incomplete/Unqualified	\vdash	Part Lost/Mi		_	Weld	
	\vdash					Contamination	\vdash	1	tions Incomplete/Unclear	-	Part Moved	· ·	_	Wrong Stock Pulled	
	-	Crushing Countersink					-	4	ned/off center	-	Positioned V		`	WYONG Stock Funcu	
					-	Cut Too Short		Mislabe		\vdash	Power Loss/	, ,	\neg_{c}	Other	
						Drawing	_	Misread		L	1	0~ [
						Drill Holes		Off-set							
	Turning Sequence Finish					Out of Calibration									
						Fit/Function		Out of	Sequence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH